



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D212-664-207
Job Sheet 178023



Part No: D212-664-207

Job Qty: 1 ea

Part Name: Aft Crosstube - Low Standard



Part Weight: 0 lbs

Job Created: 5/25/18

Due Date: 5/31/18

Type: Return

Status: Scheduled

Priority: Medium

Job Tracking No: RA295

Created By: Linda Lacelle

Description:

Note: DWG REV D/ IIN-D212-664 REV.J IPP Rev:A New Issue 07.09.12 EC verified by: JLM IPP Rev:B ECN 1100p
08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC IPP Rev: D QC5 replaced by
QC15 at step 5 KJ Verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/31/18	0.00	0.00	Start Up Crosstubes-2		AS MAY 25 2018
110	Packaging	1 pcs		5/31/18	0.00	0.00	Packaging1-3		
130	QC	1 pcs		5/31/18	0.00	0.00	QC15 N/A PD		
150	HandFXtube	1 pcs		5/31/18	0.00	1.00	HandFinish5		AS JUN 08 2018
160	QC	1 pcs		5/31/18	0.00	0.00	QC5		
180	Outsource	1 pcs		5/31/18			SKY002-VC		
190	Packaging	1 pcs		5/31/18	0.00	0.00	Packaging2		6 JUL 05 2018
200	QC	1 pcs		5/31/18	0.00	0.00	QC5		38
280	QC21-FG	1 Ea		5/31/18	0.00	0.00	QC21		9-89

Part Op 150 - ***IMMEDIATELY AFTER GRINDING***

Descriptions: 180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per
Dwg D212-664-207

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-207	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	B490 B90195

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-207TRN	1	0	0

Part Specifications



Container No: S074559



Part: D212-664-207

Job No: 178023

Serial No/Batch: S074559

Revision: D/J

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

'18 7:53 AM dart.lacelle.linda

Inspection Sheet Complete RA295

Customer QA Ref #

0

Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order Instructions
D212-664-207	B90195	1	☐ Yes	☐ Yes	☐ Yes	☐ Yes	ENGINEERING SCRAP	S065867	Customer sending crack D212-664-207 B90195 for evaluation. Tube will be scarp and kept for evaluation. Following operation will need to be preform: • Strip entire paint and primer • LPI • Evaluation from QC/ENG from any following operation
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			

QC Approval: P.D. _____

Date: 9-May-18 _____



skyservice

Work Order Traveler
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

Reference: PO040211

WO #: MWO36389

Customer: Dart Aerospace Ltd.

Dept: NDT YUL

Qty: 1

Descr:

PN:

S/N:

A/C S/N:

Make:

Model:

Reg:

TSN:

CSN:

TSO:

Sequence: 1

Task: **UNSCHEDULED**

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING FOUR (4) CROSSTUBES:

P/N: D119-796-241 Aft CROSSTUBE
1- JOB SHEET# 174947 2- JOB SHEET# 174949
3- JOB SHEET# 178857

P/N: D212-664-207 Aft CROSSTUBE
4- JOB SHEET# 178023

Action Taken:

LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-4) AS PER ASTM1417M-16

-CROSSTUBE P/N D212-664-207 JOB SHEET 178023, ONE FATIGUE CRACK FOUND ON SUSPECTED AREA ON CENTER LOWER AREA. NO CRACK FOUND ON REMAINING AREAS OF CROSSTUBE.

-NO CRACK FOUND ON THE 3 OTHER CROSSTUBES.

PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)

Date: Initial/Stamp:

15 Jun 2018



DAS
38
9-89

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:

CHRISTIAN BRIEN

ACA/SCA
Stamp



Da
15
20

**Sky Service F.B.O. Inc.**

10105 Ryan Avenue

Dorval, Quebec

H9P 1A2

Tel: 514-636-3300 Fax: 514-636-4855

Dart Aerospace Ltd.

Attention: Warran Boyd

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Description: 4 CROSSTUBES

INVOICE**Invoice Number:** MWQ37386**Invoice Date:** Jun 28, 2018**WP:** MWO36389**Terms:** NET30**Customer PO:** PO040211**Customer ID:** DARAER1C**Department:** NDT YUL**Tail No:****Type:****Serial No:**

Description	Amount
NDT MWO36389 4 CROSSTUBES	Labor: 835.00 CAD
	Flat Labor 835.00 CAD
	Sub-Total: 835.00 CAD
	HST ON: 108.55 CAD
	Total: 943.55 CAD

Electronic Funds Transfer (EFT) ACH / Wire Transfer Information:

HSBC Bank Canada

70 York Street

Toronto, Ontario

M5J 1S9

Bank#: 016

Transit No.: 10002

Account No.: 002657279001 (CDN Account)

Beneficiary: Sky Service F.B.O. Inc.

Swift Code: HKBCCATT

ABA#: 001610002

Remit to:

Sky Service F.B.O. Inc.

6120 Midfield Road

Mississauga, Ontario

Canada L5P 1B1

Thank you for your business**www.skyservice.com**



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040211

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040211

PO Date: 6/15/18

Due Date: 6/18/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

JUN 29 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174947	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	174949			Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	178857			Firmed	6/19/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
Sub Total:						3	0	3		\$626.25
2	178023	D212-664-207	Aft Crosstube - Low Standard *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
Grand Total:										\$835.00

JUL 05 2018

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.